

Work Order ID 69747

Wednesday, May 18, 2011 12:29:13 PM

Page 1

Item ID: D3324-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Base Assembly

Start Date: 5/18/2011 Start Qty: 1.00

Required Date: 5/23/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3324

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	112786
4	D3324-3	Full Length Tube	112786
2	D3324-5	Top End Tube	112786
2	D3324-7	Bottom End Tube	112786
10	D3324-9	Vertical Tube	112786

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

PL 11-05-26

1 0 BE 11/05/27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

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Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 4/05/27

121



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

X ~~Q~~ m 11/05/28

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Page 3

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

0.00

1ST COAT:

START TIME: 9:50

OVEN TEMPERATURE: 400 OF

FINISH TIME: 10:20

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 11:00

OVEN TEMPERATURE: 11:30 400 OF

H J M-L 11/05/28

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

11-05-28

1 J

M116964

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Page 4

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Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

WOC9750 @ 0.00

Packaging

EP 11/05/30 @

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/05/30 @

11-05-30
G

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 18, 2011 12:29:19 PM

Page 1

Work Order ID: 69747

Parent Item: D3324-041

Parent Item Name: Basket Base Assembly





Start Date: 5/18/2011

Required Date: 5/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 05.02.09 New issue KJ/JLM
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-3  Basket Hinge		Manufactured	No			100	Each	32.0000	2	2			
<div> <div>Location</div> <div>WA005</div> <div>33872</div> </div> <div> <div>Loc Qty</div> <div>32</div> <div>32</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3348-1  Clevis		Manufactured	No			100	Each	21.0000	4	4			
<div> <div>Location</div> <div>WA005</div> <div>44246</div> </div> <div> <div>Loc Qty</div> <div>21</div> <div>21</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3349-3  Spacer Bushing		Manufactured	No			100	Each	8.0000	2	2			
<div> <div>Location</div> <div>WA005</div> <div>41831</div> </div> <div> <div>Loc Qty</div> <div>8</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3367-1  Mounting Bracket		Manufactured	No			100	Each	36.0000	2	2			
<div> <div>Location</div> <div>WA005</div> <div>43228</div> </div> <div> <div>Loc Qty</div> <div>36</div> <div>36</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

Cpl 11.05.26

②

Cpl 11.05.26

④

Cpl 11.05.26

②

Cpl 11.05.26

②

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Picklist Print

Wednesday, May 18, 2011 12:29:19 PM

Page 2

Work Order ID: 69747

Parent Item: D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 5/18/2011

Required Date: 5/23/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased

No

100

f

555.7500

.46.6

49.05263



4130 Square tube .500 x .500 x .035w

Pl 11.05.26

Location

Loc Qty

Loc Code

MAT034

555.75

109127

216

109385

15.75

112786

324

M569EX0.50-18F

Purchased

No

100

sf

66.0000

28

49.0526
28



569 Expanded Metal

Pl 11.05.26

Location

Loc Qty

Loc Code

MAT018

66

112776

66

28

Wednesday, May 18, 2011 12:29:19 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

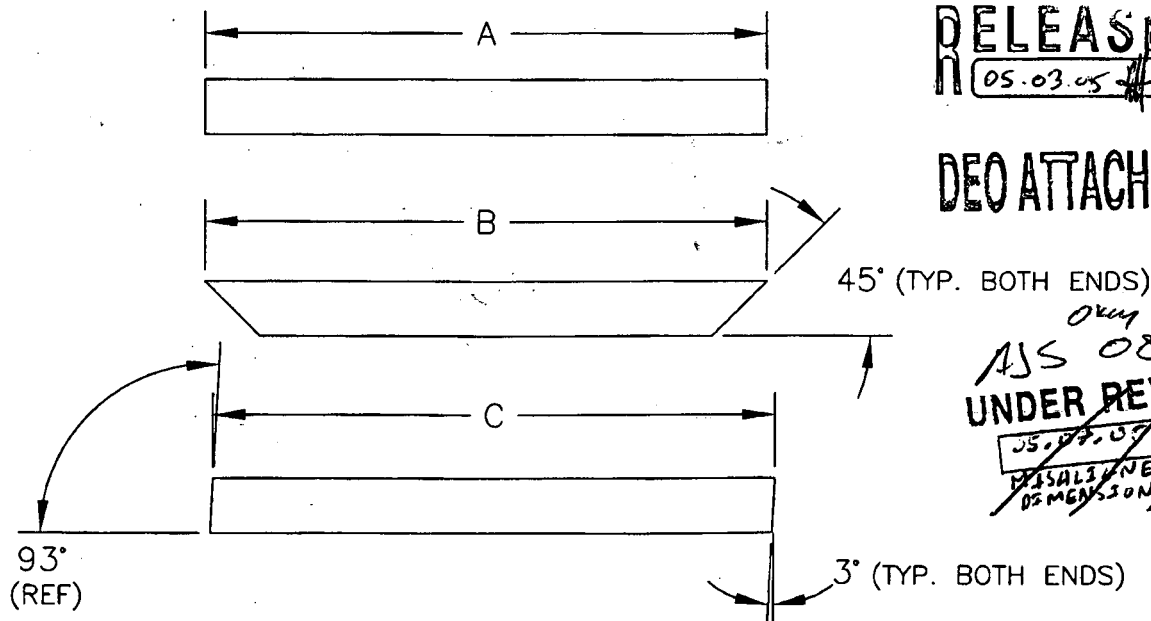
WORK ORDER

NO. 6974711-05-18

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY SCALE NTS	
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET

**RELEASED**
05.03.05**DEO ATTACHED**

OK
155 08.12.15
UNDER REVIEW
05.07.07 PH
DISALIGNED
DIMENSION P6a

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

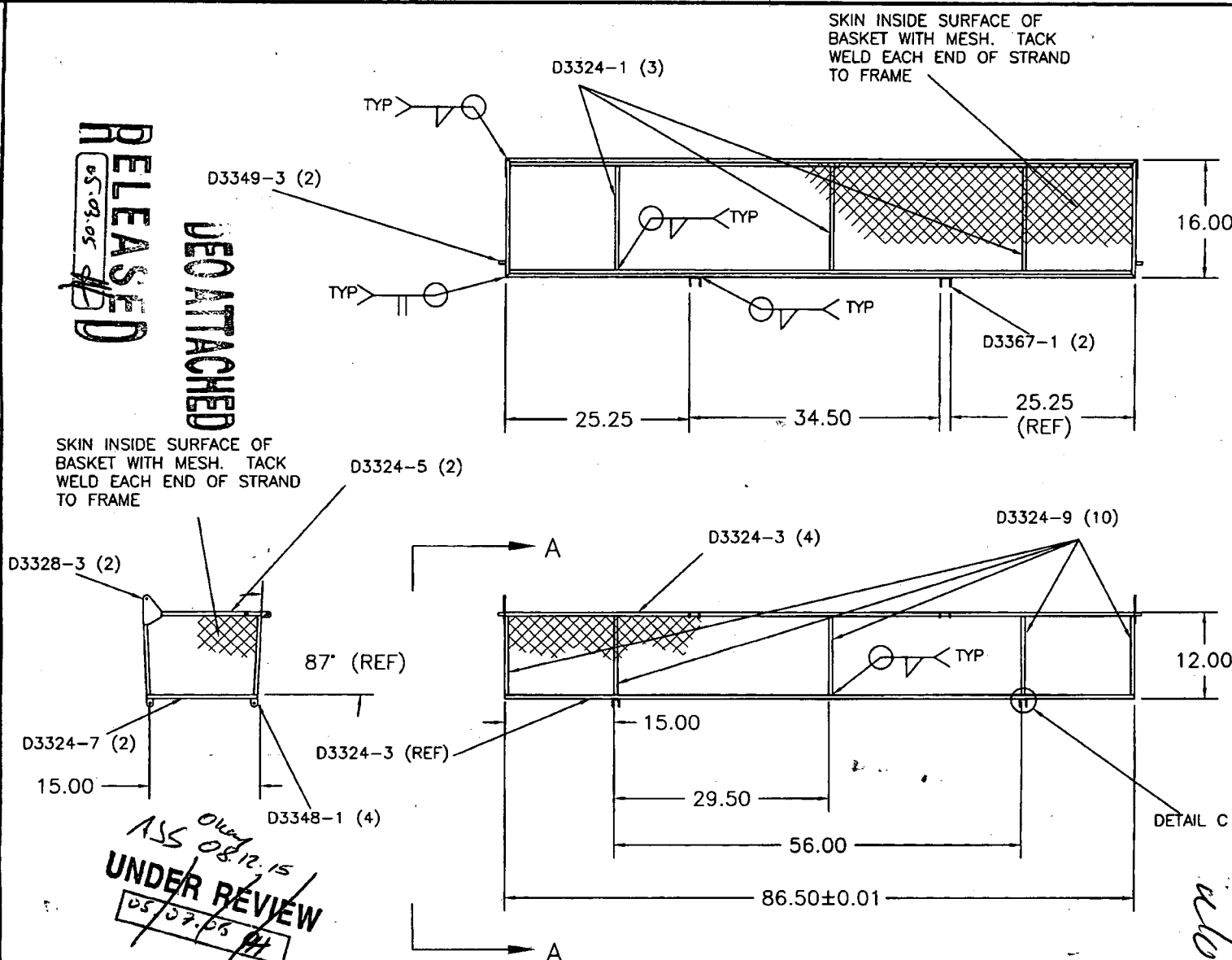
DESIGN	DRAWN BY	DART AEROSPACE LTD
PH	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3324
DATE	TITLE	REV. B
05.03.04	BASKET BASE ASSEMBLY	SHEET 2 OF 3
		SCALE 1:20

also 66447

RELEASED
05.03.05

DEF ATTACHED

SKIN INSIDE SURFACE OF BASKET WITH MESH. TACK WELD EACH END OF STRAND TO FRAME



D3324-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

ASS 06.12.15
UNDER REVIEW
05/07/05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

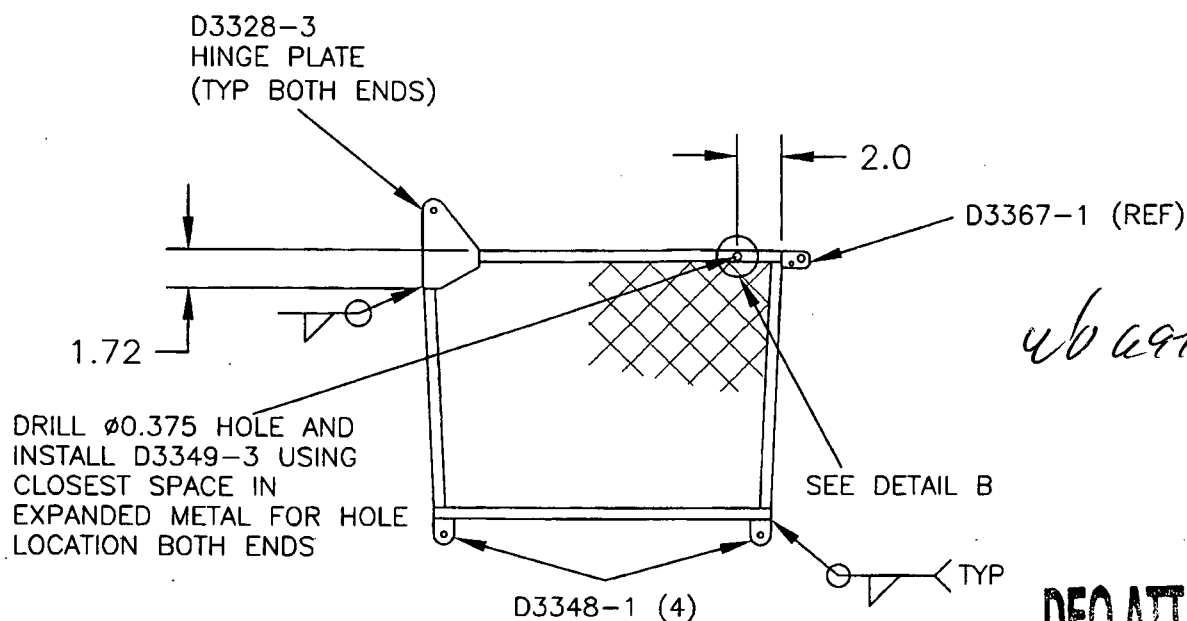
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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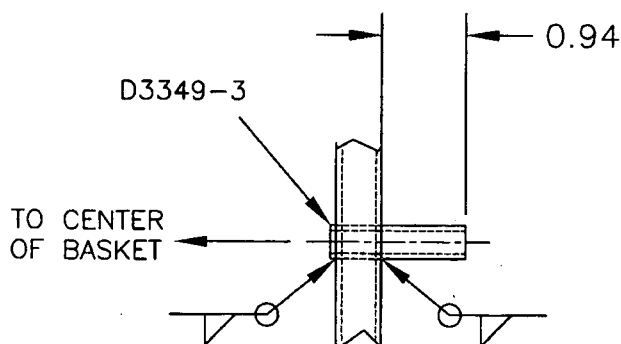
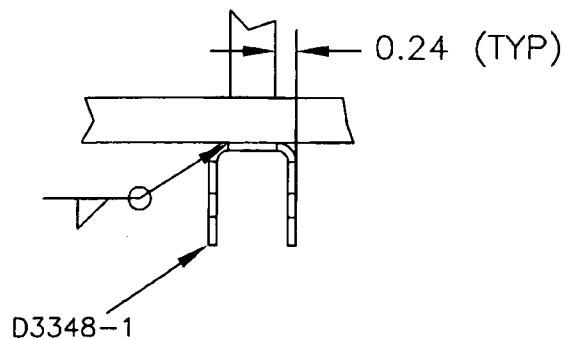
DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



VIEW A-A

DEO ATTACHED

RELEASED
05.03.05DETAIL B
(SCALE 1:2)DETAIL C
(SCALE 1:2)

05.03.12.15
UNDER REVIEW
05.03.06

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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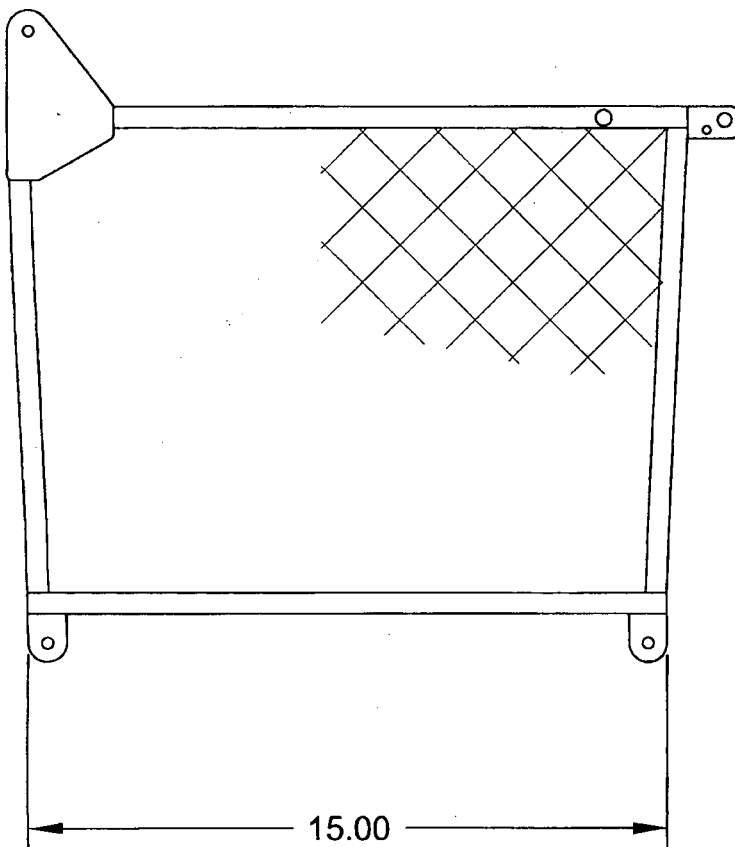
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DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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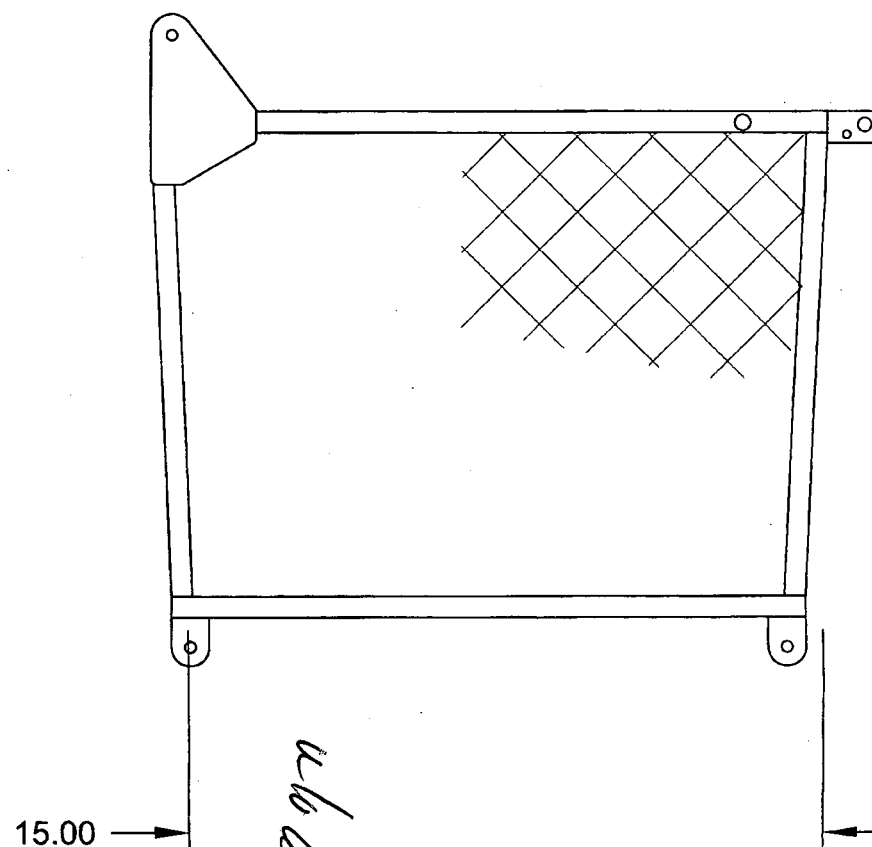
DRAWING NO. D3324	TITLE BASKET BASE ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3324-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 08.11.28	DATE 08.11.28	DATE 08/12/01	DATE 08/12/01	DATE 08.12.01			

SHEET 2 MODIFY SIDE VIEW OF D3324-041 AS SHOWN:

IS:



WAS:



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